

Work Order ID 69804

Thursday, May 19, 2011 1:39:07 PM



Page 1

Item ID: D4004-3

Accept



Setup Start



Revision ID:

Item Name: Strut Lock Bracket

Stop



Start Date: 5/19/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4004

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg (D4004-3F)

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

B11-6-22

(12)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-6-22

Work Order ID 69804

Thursday, May 19, 2011 1:39:07 PM

Page 2

Item ID: D4004-3

Accept

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Start Date: 5/19/2011 Start Qty: 5.00

Required Date: 5/20/2011 Req'd Qty: 5.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

Bend as per dwg

0.00



Brake NC

Memo

0.00

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Work Order ID 69804

Thursday, May 19, 2011 1:39:07 PM



Page 3

Item ID: D4004-3

Revision ID:

Item Name: Strut Lock Bracket

Start Date: 5/19/2011 Start Qty: 5.00

Required Date: 5/20/2011 Req'd Qty: 5.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start



QC: Date:

SPC (Y/N): Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

12 BR 11-6-23

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

12x Ø M-11/06/23

170

Identify as per dwg & Stock Location: G-A

0.00



Packaging

Memo

0.00

Packaging

EP 11/06/27 (12)

Work Order ID 69804

Thursday, May 19, 2011 1:39:07 PM



Page 4

Item ID: D4004-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut Lock Bracket

Start Date: 5/19/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/27

MF
11-06-27

Picklist Print

Thursday, May 19, 2011 1:39:04 PM

Page 1

Work Order ID: 69804

Parent Item: D4004-3

Parent Item Name: Strut Lock Bracket



Start Date: 5/19/2011

Required Date: 5/20/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP rev A 09.12.15 new issue Prelim EC verified by:DD IPP Rev:B
10.05.17 as per ECN10-562 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	309.0700	0.024	0.126316			

2024-T3 .063 sheet

Location

Loc Qty

Loc Code

MAT022

309.07

113867

0.19

117018

40.38

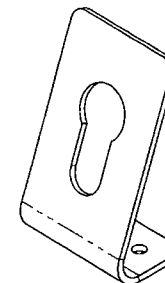
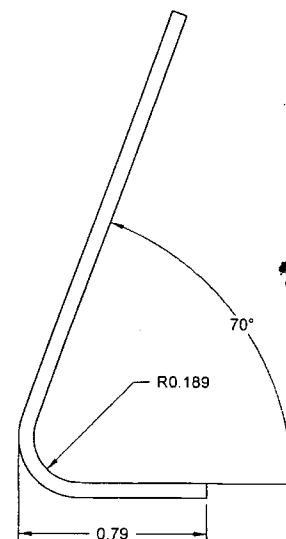
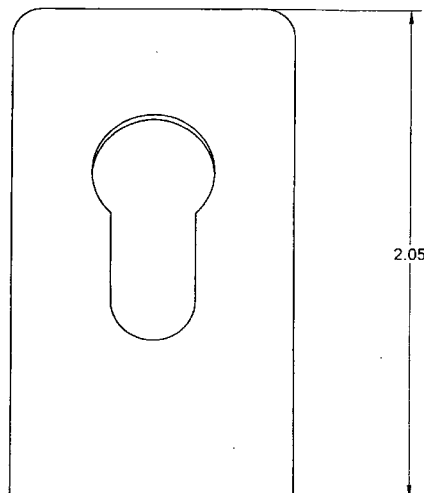
117392

268.5

113867

B11-6-22

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4004-3	REF JCA-M47-2-19



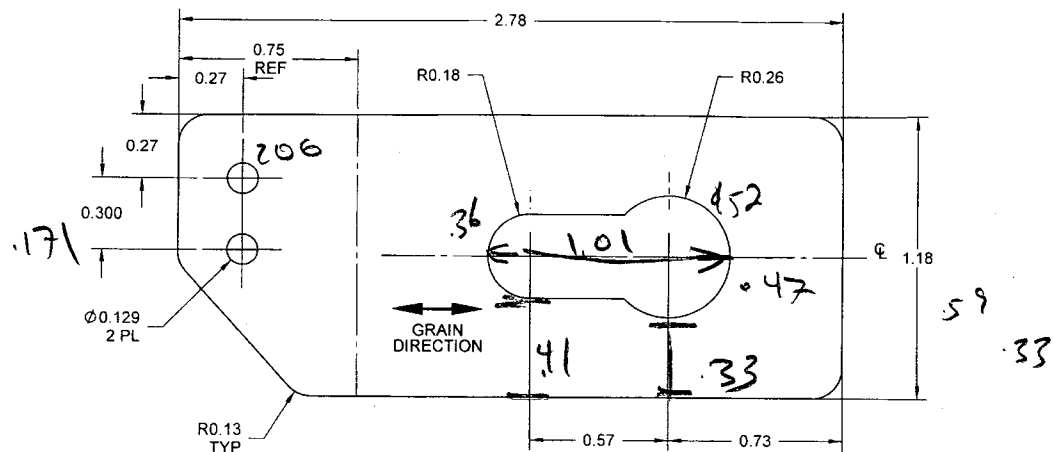
D4004-3 STRUT LOCK BRACKET

W/66804

RELEASED
2010-05-05
MB

- NOTES:**
- 1) MATERIAL: MADE FROM D4004-3F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.02 lbs

DESIGN	<i>JS</i>	DART AEROSPACE LTD	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JS</i>	D4004	SHEET 5 OF 11
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	SIDE RESTRAINT	NTS
DATE	10.02.10	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D4004-3F FLAT PATTERN

RELEASED
2010-05-05
MP

9804

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.02 lbs

DESIGN	<i>JE</i>	DART AEROSPACE LTD	
DRAWN	<i>JE</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JE</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JE</i>	D4004	SHEET 6 OF 11
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